



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2721-041
Job Sheet 206265



Part No: D2721-041

Job Qty: 7 pcs

Part Name: 206B Step Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/28/20

Job Tracking No:

Due Date: 3/12/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:F As Per Ecn 766 06-01-06 JLM IPP Rev:G add wing walk DD 10.02.24 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Steps - 1	7 pcs			0.00	13.29	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	Large Fab - Steps - 2 - B4B	7 pcs			0.00	7.00	Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
							Large Fab - 11 - B4B (Various)		
							Large Fab - 12 - B4B		
					00	0.00	QC 9 - 10		
							QC 9 - 18	DAS	
							QC 9 - 24	24	
							QC 9 - 43	9-89	
							QC 9 - 50		
							QC 9 - 9		

FG Doc



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S254953



Part: D2721-041

Job No: 206265

Serial No/Batch: S254953

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/12/20

pcs

Plex 1/28/20 12:54 PM Dart.lajeunesse.marie

130 QC 5	7 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
140 Handfinish - 1-1 Chemical-B4B	7 pcs	0.00 1.58	Handfinish - 1 - 1 - B4B	all 20-2-26
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
150 QC 7	7 pcs	0.00 0.00	QC 7 - 10	
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	
			QC 7 - 17	
			QC 7 - 18	
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	
			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	

			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	
			QC 7 - 61	
			QC 7 - 81	
			QC 7 - 76	
			QC 7 - 79	
			QC 7 - 83	
			QC 7 - 82	
160	Large Fab - Steps - 3 - B4B	7 pcs	0.00 13.29	Large Fab - 1 - B4B
				Large Fab - 10 - B4B
				Large Fab - 2 - B4B
				Large Fab - 3 - B4B
				Large Fab - 4 - B4B
				Large Fab - 5 - B4B
				Large Fab - 6 - B4B
				Large Fab - 7 - B4B
				Large Fab - 8 - B4B
				Large Fab - 9 - B4B
				Large Fab - 11 - B4B (Various)
				Large Fab - 12 - B4B
170	QC 10	7 pcs	0.00 0.00	QC 10 - 10
				QC 10 - 18
				QC 10 - 24
				QC 10 - 43
				QC 10 - 50
				QC 10 - 58
				QC 10 - 9
				QC 10 - 68
180	QC 5	7 pcs	0.00 0.00	QC 5 - 10
				QC 5 - 12
				QC 5 - 17
				QC 5 - 18
				QC 5 - 19
				QC 5 - 22
				QC 5 - 24
				QC 5 - 3
				QC 5 - 43
				QC 5 - 49
				QC 5 - 51
				QC 5 - 58
				QC 5 - 68
				QC 5 - 9
				QC 5 - 50
				QC 5 - 30
				QC 5 - 40
				QC 5 - 61
				QC 5 - 81
190	Handfinish - 1-2- Chemical- B4B	7 pcs	0.00 1.17	Handfinish - 1 - 1 - B4B
				Handfinish - 1 - 2 - B4B
				Handfinish - 1 - 3 - B4B

DAS
82
9-89

FEB 21 2020

SL

33.50

DAS
24
9-89DAS
24
9-89

MAR 10 2020

				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
200	Powdercoat - 1 White GI(A)- B4B	7 pcs	0.00 1.53	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	20-03-10
				Powdercoat - 4 - B4B	
210	QC 3	7 pcs	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	BEB 20-03-11
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
220	Handfinish - 3-1- WingWalk- B4B	7 pcs	0.00 1.40	Handfinish - 3 - 1 - B4B	
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	BEB 20-03-11
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
230	QC 3	7 pcs	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	

DAS 34 9-89

DAS 59 9-89

DAS 81 9-89

MAR 11 2020

			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
240 Packaging 3-1 - Stock - B4B	7 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	DAS
			Packaging 3 - 25 - B4B	72
			Packaging 3 - 26 - B4B	9-89
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
250 QC 21 - SA	7 pcs	0.00 0.00	QC 21 - SA - 21	DAS
			QC 21 - SA - 70	21
			QC 21 - SA - 53	9-89

Part Op 100 - Fabricate per Drwg - Cut D2721-1 using D2622 extrusion as per Dwg D2721 Deburr and bevel ends for welding
 Descriptions: DRILL VENT HOLE AS PER SECTION A-A with sig DT 10463

110 - Large Fab - Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT10215A followed by Jig DT10215B A/R AL Rod Batch: _____ Grind end cap welds flush

120 - QC9- Inspect visual per QSI004- Fusion Welds

130 - QC5- Inspect part completeness to step on W/O

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

160 - Large Fab - Inspect for foreign object per QSI 024 Weld Remaining end cap as per Dwg D2721 BLOCK VENT HOLE USING RIVET AS PER DWG A/R AL Rod Batch: _____ Grind End Cap Welds Flush

170 - QC10- Inspect visual per QSI004- ground welds

180 - QC5- Inspect part completeness to step on W/O

190 - Chemical Conversion Coat per QSI005 4.1

200 - White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum - START TIME: 11:00 OVEN TEMPERATURE: 320°
FINISH TIME: 11:30 M035590

210 - QC3- Inspect Part Finish

220 - Wing Walk as per dwg QSI005 4.4 Batch _____

230 - QC3- Inspect Part Finish

240 - Identify as per dwg & Stock Location: _____

250 - QC21- Final Inspection - Work Order Release

Job BOM

014415

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	7 pcs (1 ea)	100-Large Fab - Steps - 1	5243427
D2734	Step End Plate	7 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	5242135
D3461-1	Mounting Plate	7 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	5252981
D3461-3	Mounting Plate	7 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	5253003
D3461-5	Mounting Plate	7 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	5253018
D3461-7	Mounting Plate	7 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	5253029
MS20601-AD4W2	Rivet	7 Ea (1 ea)	110-Large Fab - Steps - 2 - B4B	5228472
D2734	Step End Plate	7 pcs (1 ea)	160-Large Fab - Steps - 3 - B4B	5259367

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	7	133	0
110-Large Fab - Steps - 2 - B4B	D2734	7	34	0
	D3461-1	7	9	0
	D3461-3	7	5	0
	D3461-5	7	19	0
	D3461-7	7	8	0
	MS20601-AD4W2	7	38	0
160-Large Fab - Steps - 3 - B4B	D2734	7	34	0

Part Specifications

Specifications could not be found.

Plex 1/28/20 12:54 PM Dart.lajeunesse.marie

110 - 14415

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☐ Rec/Store/Packaging ☐ Skid-tube ☐ Machining ☐ Large Fab ☐				Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date :	Sequence #:	QTY Affected :		MRB (QS1042)					
Description Work Order Deviation		Disposition							
		Completed By							
		Lead hand / Supervisor							
		QC / QA Coordinator							

Root Cause		FAULT CATEGORY									
Operator	Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong							
Manufacturing Process	Bending	Misaligned/off center	Folio/Program	Outside Tolerance							
Equip/Tooling	Crushing	BOM/Route	Grain Direction	Drawing							
Handling/Preservation	Cracks	Broken/Damage/Defect	Weld	Finish							
Material	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing							
Product Improvement	Marks/Chatter	Drill Holes	Out of Sequence	Misread							
Process Improvement	Mislabeled	Fit/Function	Off-set/Set-up								
Human Factors											
Other/Details:											